

shp 27/04

# Work Order ID 68594

Monday, April 18, 2011 11:18:47 AM



Page 1

Item ID: D3713-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Assembly

Start Date: 4/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: 

Date:

Tooling:

Date:

Stop



QC

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3713

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- drill holes in both D3715-1 as per dwg D3715  
2- deburr  
3- assemble as per dwg D3713 and weld as per QSI004

Pl 11.04.21

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut mesh as per dwg D3743  
2- weld mesh as per dwg D3713

Pl 11.04.21

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/12

@

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

R 11.04.26

1

0

BB 11/04/26

140



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

M 11.51.28

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10.30  
320°  
11:00

1

BR 11-4-26

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

1 - d 10 11/4/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

0.00



HandFinishing

HandFinish

Memo

0.00

M11731 S

Hand Finishing

1-Apply Wing Walk on mesh as per Dwg D3713 and QSI 005 4.4

2-apply armor shield over label on lid only

→ M 11-04-26

x1 d M 11/04/26

170

0.00



QC3- Inspect Part Finish

QC

Memo

0.00

Quality Control

E 54/04/27 @

180

0.00



Identify as per dwg &amp; Stock Location: GA

Packaging

Memo

0.00

W/ 68592

Packaging

E 54/04/27 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

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Start Date: 4/18/2011 Start Qty: 1.00



Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/27 [Signature]  
ME  
11-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Monday, April 18, 2011 11:18:44 AM

Page 1

Work Order ID: 68594

Parent Item: D3713-042

Parent Item Name: Lid Assembly



Start Date: 4/18/2011

Required Date: 4/27/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-01-30 DD verified by:EC  
IPP Rev:B change to revB ecn 1145 08-03-19 DD verified by:EC IPP Rev:C  
add label DD 10.03.23 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D2327-1  Spacer Bushing		Manufactured	No			100	Each	23.0000	2	2			
---------------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
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WA005	23	
60174	3	
64899	20	

✓ D2329  Label Plate		Manufactured	No			100	Each	7.0000	1	1			
----------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

WA006	7	
40488	7	

✓ D2581  Mounting Bracket		Manufactured	No			100	Each	22.0000	2	2			
---------------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

WA005	22	
66806	22	

✓ D3749-1  Hinge Half		Manufactured	No			100	Each	9.0000	3	3			
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Location	Loc Qty	Loc Code
----------	---------	----------

WA005	9	
57748	9	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Monday, April 18, 2011 11:18:44 AM

Page 2

Work Order ID: 68594

Parent Item: D3713-042

Parent Item Name: Lid Assembly

Start Date: 4/18/2011

Required Date: 4/27/2011

Start Qty: 1.00

Required Qty: 1.00

✓ M304TS0.750W.065 Purchased No  
304 SQ Tube .75x.75x.065W



663.2940 31.022 32.65474



SAD 11-04-20

Location

Loc Qty

Loc Code

WA007

663.2939906

116267

191.526272

116763

471.767719

32.6548

✓ M304EX0.75-16F Purchased No  
Expanded Metal Flat SS



387.1916 17

17.89474



SAD 11-04-20

Location

Loc Qty

Loc Code

WA

387.1916

115012

150

117197

237.1916

17.8948

D2258-300 5 Manufactured No  
Label



160 Each

7.0000

1

1



11 04 27

Location

Loc Qty

Loc Code

ST505

7

55718

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

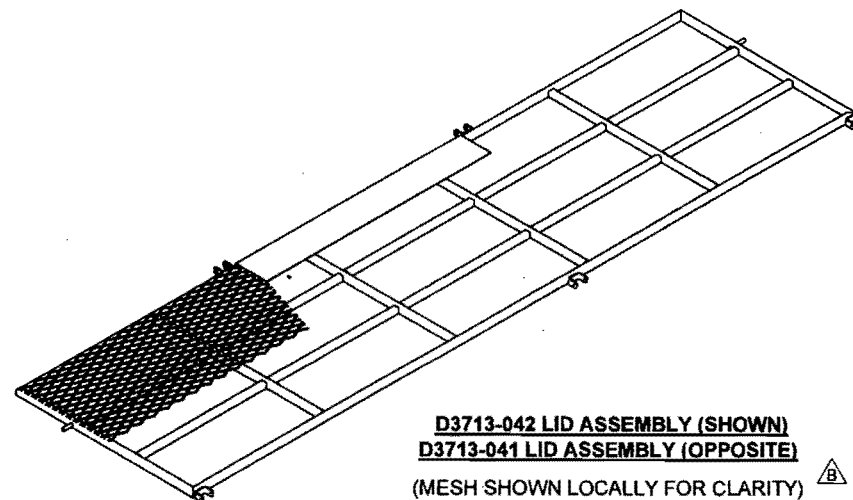
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3713-041	LID ASSEMBLY
	X	D3713-042	LID ASSEMBLY
2	2	D2327-1	SPACER
1	1	D2329	LABEL PLATE
2	2	D2581	MOUNTING BRACKET
2	2	D3714-1	RIB
2	2	D3715-1	RIB
10	10	D3716-1	RIB
4	4	D3732-1	RIB
1	1	D3743-1	MESH
3	3	D3749-1	HINGE HALF



W/O 65594

08.02.27

#### NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF ON D3712-041/042 BASKET BASE ASSEMBLY

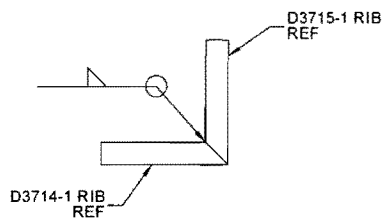
B	SHEET 1 -042 WAS -041; ADDED CORRECT -041 ASSEMBLY, NOTE 9 ADDED, ZONE C2 LID ASSEMBLY WAS D3713-041, WEIGHT WAS 36 lbs. SHEET 2 ZONE B5 LID ASSEMBLY WAS D3713-041, ZONE D6 31.53 DIM WAS 31.64, ZONE D3 54.40 DIM NOW REF ZONE D2 0.13 REF DIM ADDED ZONE B8 29.65 DIM WAS 29.77, ZONE D3 & D2 FLAG NOTE 9 ADDED.		AJS	08.02.27
A	NEW ISSUE		AJS	08.02.01
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3713</b> TITLE <b>LID ASSEMBLY</b> DATE <b>08.02.27</b> <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	AJS			
CHECKED	CE			
MFG. APPR.	DS			
APPROVED	AP			
DE APPR.	AP			
DATE	08.02.27		REV. B	SHEET 1 OF 3
			SCALE	NTS



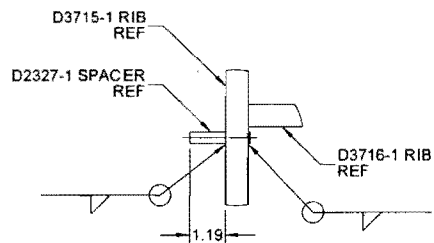




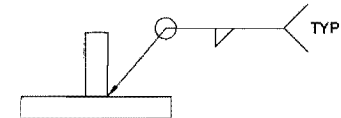




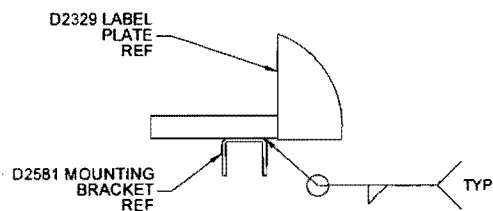
**DETAIL A: TYP CORNER WELDS**  
SCALE 4X  
(MESH NOT SHOWN FOR CLARITY)



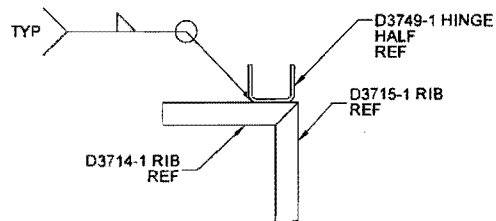
**DETAIL B**  
TYP BOTH ENDS  
SCALE 4X



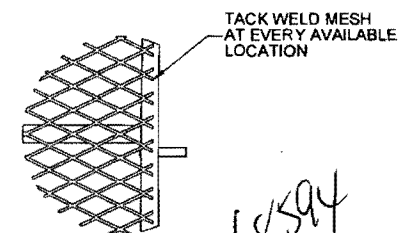
**DETAIL C**  
TYP  
SCALE 4X



**DETAIL D**  
SCALE 4X



**DETAIL E**  
SCALE 4X



**DETAIL F**  
SCALE 5X

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